



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D4148-041
Job Sheet 182176



Part No: D4148-041

Job Qty: 4 ea **DAS 21 9-89**

Part Name: Fwd Crosstube Lug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/20/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV:D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Small Fab-3	9-89	AUG 21 2018
100	Small Fab	4 pcs	9/7/18	9/7/18	0.00	1.20	Small Fab-6	9-89	smB DAS 38
110	QC	4 pcs	9/7/18	9/7/18	0.00	0.00	QC5	9-89	38
120	Packaging	4 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2	5/539 6 9-89	AUG 27 2018
130	QC21-SA	4 Ea	9/7/18	9/7/18	0.00	0.00	QC21	6 9-89	AUG 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	10 8 Ea (2 ea)	90-Start up Operation	5084112
AN4C13A	Bolt	15 12 Ea (3 ea)	90-Start up Operation	5087121
D2690-6	Lanyard	5 4 Ea (1 ea)	90-Start up Operation	5091895
D3910-1	Crosstube Lug	5 4 Ea (1 ea)	90-Start up Operation	5102588
D4091-1	Mounting Lug	5 4 Ea (1 ea)	90-Start up Operation	5062930
D4148-1	Crosstube Lug Plate, Fwd	10 8 Ea (2 ea)	90-Start up Operation	5073830
D4148-3	Stud Receiver, Lower	5 4 Ea (1 ea)	90-Start up Operation	5088596
D4148-5	Eyebolt Stud	5 4 Ea (1 ea)	90-Start up Operation	5088928x1 5101939 x-1
MS17984-C413	Quick Release Pin	5 4 pcs (1 ea)	90-Start up Operation	509568X2 508521013
MS20615-4M18	Rivet	40 32 Ea (8 ea)	90-Start up Operation	5090631
MS21043-3	Nut	10 8 Ea (2 ea)	90-Start up Operation	5062620
MS21043-4	Nut	15 12 Ea (3 ea)	90-Start up Operation	5089277
NAS1149C0332R	Washer	20 16 Ea (4 ea)	90-Start up Operation	5056493x6 5089882 V14
NAS1149C0432R	Washer	30 24 Ea (6 ea)	90-Start up Operation	5052052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	8	154	0
	AN4C13A	12	249	0
	D2690-6	4	25	0
	D3910-1	4	23	0
	D4091-1	4	20	0
	D4148-1	8	46	0
	D4148-3	4	5	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		QTY Effective : _____		MRB (QSI042) Approval	
Order Deviation		Disposition			
Dart Aerospace Ltd. 1270 Aberdeen Street Newbury ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/21/16 Container No: S104016 Part: D4148-041 Job No: 182176 Serial No/Batch: S104016 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			
FAULT CATEGORY Environment ☐ Design ☐ Documentation ☐ Equipment/Tools ☐ Handling/Preparation ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____			

D4148-5	4	11	0
MS17984-C413	4	28	0
MS20615-4M18	32	376	0
MS21043-3	8	1,150	0
MS21043-4	12	1,364	0
NAS1149C0332R	16	4,742	0
NAS1149C0432R	24	1,129	0

Part Specifications

Specifications could not be found.

Plex 8/20/18 12:44 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					